



Dart Aerospace Ltd.
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RBA8100-80902
Job Sheet 193876



Part No: RBA8100-80902

Job Qty: 2 pcs

Part Name: Wrench Fuel Cell Assembly Set



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14925*

Note: DWG RBA8100-80902 Rev 4 IPP Rev. A 19.04.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	6/28/19		0.25	0.20	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	6/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
120	QC 8	2 pcs	6/28/19		0.00	0.00			



Container No: S197415

Part: RBA8100-80902

Job No: 193876

Serial No/Batch: S197415

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 07/11/19

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JUL 11 2019

				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130	Packaging 3-1 - Stock - B4B	2 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	2 pcs	6/28/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 100 - Small Fab-9 (Small Fab) 1-The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as Descriptions: per DWG. 2-Ensure pieces do not hit/rub up against each other in the bag. Package accordingly. 110 - QC5 (QC5- Inspect part completeness to step on W/O)					

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120 - QC8 Machining-5 (QC8- Inspect parts - second check)

130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94895A823	Hex Nut	2 Ea (1 ea)	100-Small Fab - 1	5118676
RBA8100-80902-206	Wrench Assembly	2 pcs (1 ea)	100-Small Fab - 1	5194449
RBA8100-80902-300	Weldment	2 pcs (1 ea)	100-Small Fab - 1	5191086
RBA8100-80902-9	Wrench Assembly	2 pcs (1 ea)	100-Small Fab - 1	5197357

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	94895A823	2	50	0
	RBA8100-80902-206	2	0	0
	RBA8100-80902-300	2	0	0
	RBA8100-80902-9	2	0	0

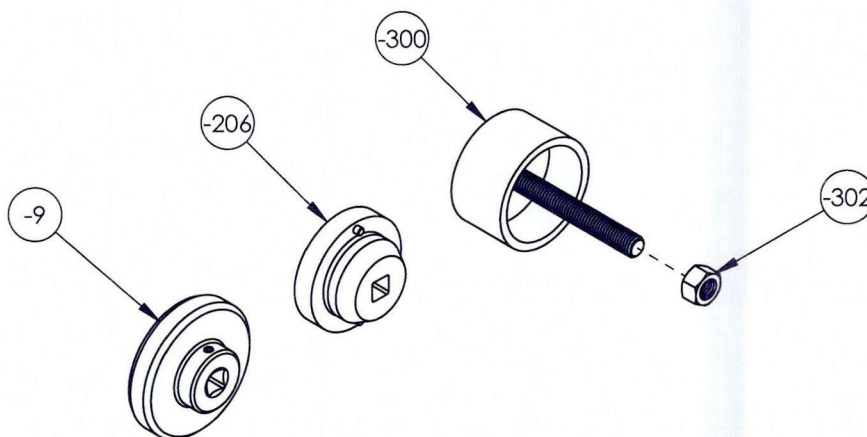
Part Specifications

Specifications could not be found.

Plex 4/24/19 8:03 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		MERGED ASSY. DWG & REMOVED OBSOLETE DWG.	8/9/2006		
1A		CH'D TITLEBLOCK & REVISION BLOCK, ADDED FINISH SPEC P/N -1, -301A, -302A, & -304A.	8/13/2009	RJC	
2		DELETED Ø.219 THRU HOLE FOR RETAINER BALL & ADDED R.120 (x4) x .600 BALL RETAINERS FOR P/N -201 PER G.E., LABELED SECTION VIEWS A-A & B-B.	9/21/2009	RJC	
2A		CH'D P/N'S FROM 200, 301A, 302A, 304A TO MATCH MANUFACTURING SYSTEM P/N'S PER J.D.	10/26/2009	RJC	RW
3		ADDED -9 & -206 WRENCH ASSEMBLIES TO MATCH OEM DRAWINGS & CH'D ENGRAVE NOTES PER E.B. CH'D -201 DOWEL PIN HOLE FROM PRESS FIT FOR .188 DOWEL PIN TO Ø.1874-.1869.	5/25/2012	RJC	EB
4	15-0297	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS .500 SQUARE +.010 -.005 IS 2X .503-.508. ADDED DIMS 2X .670 MIN, Ø.70, 120°. -2 ADDED B/O #91375A537. -9 ADDED DWG. -201 CH'D DIMS WAS .256 IS 4X .303-.315, WAS .500 SQUARE +.015 -.000 IS 2X .503-.508. ADDED DIMS 2X .670 MIN, Ø.70, 120°. -202 ADDED B/O #98381A507. -206 ADDED DWG. -300 DELETED DIMS 4.250. CH'D DIM WAS .10 IS (.100). ADDED DIM 4.35. -301 WAS B/O IS MODIFIED. ADDED DWG. CH'D B/O WAS #98750A107 IS #98750A108. -302 ADDED B/O #94895A823.	9/16/2015	DPD	JAG



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WITHOUT NOTICE
WORK ORDER

NO. 193876 MCT
19-04-24

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.				
		1		-1		WRENCH	41L40/4140		3	TITLE WRENCH - FUEL CELL ASSY			
		1	B/O	-2		SECKET HEAD SET SCREW	STEEL	1/4-20 X 1/2 (MCMASTER-CARR #91375A537)	2				
		X		-9	1	WRENCH ASSY.			2	DWG NO. RBA8100-80902			
	1			-201		WRENCH	1018/1020		5				
	2			-202		DOWEL PIN		Ø3/16 X 5/8 (MCMASTER-CARR #98381A507) MODIFIED	6	REV 4			
	X			-206	1	WRENCH ASSY.			4				
	X			-300	1	WELDMENT			7	MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
	1			-301		ALL-THREAD	STEEL	1/2-13 X 4 (MCMASTER-CARR #98750A108) MODIFIED	8				
			B/O	-302	1	HEX NUT	STEEL	1/2-13 (MCMASTER-CARR #94895A823)	1	DRAWN BY: COLE APPROVED  HEAT TREAT FINISH SPEC USED ON MODEL MD			
	1			-304		CUP	1018/1020		9				
ASSY -300	ASSY -206	ASSY -9								SCALE 1:4 DATE 7/30/2004 SHEET 1 OF 9			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					